

July 08, 2016 11:54:47 AM

Page 1

16-07-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Page 2

Reference:

Stop ***NR2***

BATCH: 134826

3 JUL 14 2016

**DAS
24
9-89**

Quality Control

③ 16-07-19

DAS
9
—9-89

Quality Control

② 16-07-19.

DAS
9
9-89

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		OTHER : ☐							

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Page 3

Reference:

Stop ***NR2***

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

m 134092

0.02

Powdercoat

Memo

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.01

Quality Control

180

Small Fab

0.00

180

Small Fab

Memo

0.08

Small Fab

1- match drill cover to existing holes in support
2- assemble as per dwg

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Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 148825

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148825

Page 4

Item ID: PB67-43001-15

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 7/8/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190						<u>3</u>			DAS 38
QC	Memo	0.01							JUL 25 2016
Quality Control									
200	Identify as per dwg & Stock Location: <u>ME222</u>	0.00							
200									
Packaging	Memo	0.01							3 JUL 28 2016 DAS 24 9-89
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.05							DAS 21 9-89
Quality Control									AUG 03 2016

SW 7/28/16

DQA: _____ Date: _____



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OTHER :									

Picklist Print

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Page 1

Work Order ID: 148825

148825

Parent Item: PB67-43001-15

PB67-43001-15

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780		Purchased		No			Each	35.0000		3			DAS
MS124780									**			16-07-19	32
HELICAL INSERT													9-89
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST260a			19		3			
					m128173			19					
					ST316			16					
					111064			16					
MS27039-1-10		Purchased		No			Each	284.0000		24			DAS
MS27039-1-10									**				9-89
SCREW													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					CA			31					
					m128635			31					
					GA			14					
					m129541			14					
					ST280			239					
					m134676			239		24			
NAS1149D0316J		Purchased		No			Each	1,624.000		24			DAS
NAS1149D0316J									**				9-89
Washer													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
					ST264			1624					
					M134502			1624					

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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		OTHER : _____											

Picklist Print

Page 2

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Work Order ID: 148825

148825

Parent Item: PB67-43001-15

PR67-43001-15

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0363J

Purchased

No

Each

1,744.000

24

NAS1149D0363J

**

DAS

Washer

8
9-89LocationLoc QtyLoc Code

GA

418

m134055

418

ST263

1326

m134676

326

m134955

1000

Each

14.0000

3

**

JUL 12 2016

DAS
24
9-89

PB67-43001-249

Manufactured

No

PR67-43001-249

Inner Tube Bushing

LocationLoc QtyLoc Code

WA003

14

133726

14

Each

13.0000

3

**

JUL 12 2016

DAS
24
9-89

PB67-43001-253

Manufactured

No

PR67-43001-253

Gusset

LocationLoc QtyLoc Code

Mezz2

13

116441

1

139182

12

Each

9.0000

3

**

JUL 12 2016

DAS
24
9-89

PB67-43001-254

Manufactured

No

PR67-43001-254

Gusset

LocationLoc QtyLoc Code

Mezz2

9

133227

1

139181

8

1

2

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Shop Packet Print

Page 2

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☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish																																																																						
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread																																																																						
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence																																																																						
OTHER :																																																																									

Picklist Print

July 08, 2016 11:54:47 AM

Page 3

Work Order ID: 148825

148825

Parent Item: PB67-43001-15

PB67-43001-15

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-257

Manufactured No

Each 3.0000

3

PR67-43001-257

Inner Tube

**

JUL 12 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

3

140916

3

Each

7.0000

3

**

JUL 12 2016

DAS
24
9-89

PB67-43001-71

Manufactured No

PR67-43001-71

20° Blade Support Assembly

Location

Loc Qty

Loc Code

Mezz2

7

139179

7

Each

12.0000

3

**

DAS
24
9-89

PB67-43001-73

Manufactured No

PR67-43001-73

20 Degree Cover Plate

Location

Loc Qty

Loc Code

Mezz2

12

111758

1

138692

10

90817

1

Each

21.0000

3

**

DAS
24
9-89

PB67-43001-83

Manufactured No

PR67-43001-83

D-Pad Assembly, Short

Location

Loc Qty

Loc Code

Mezz2

21

138687

21

3

DQA: _____ Date: _____

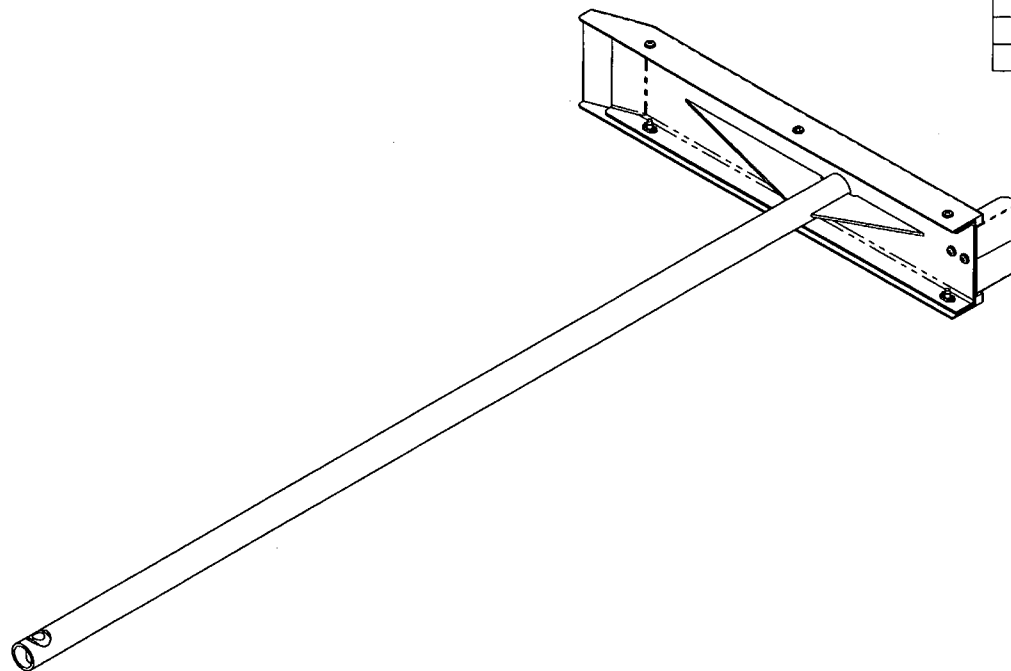


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									



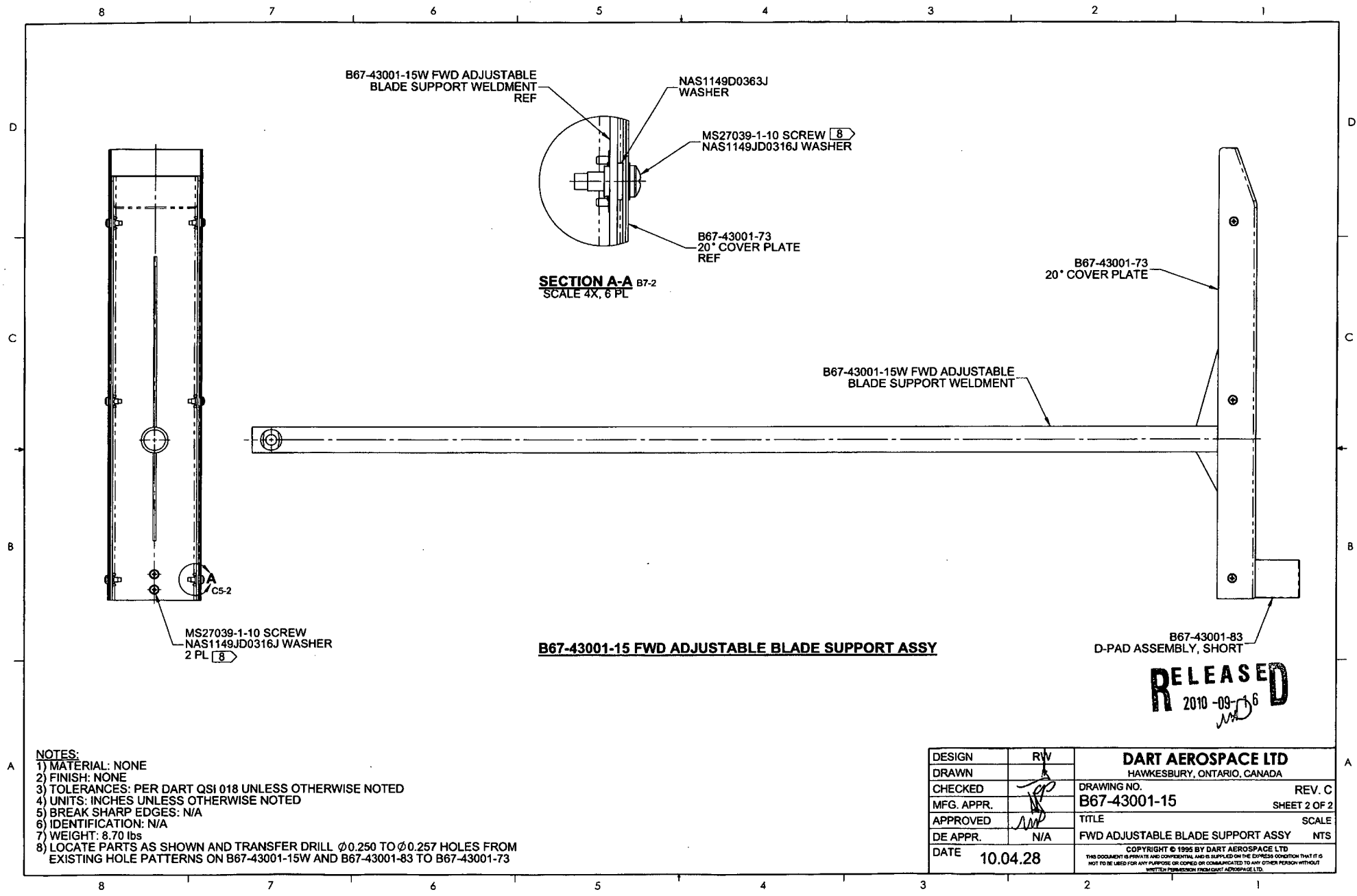
B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -15	P/N	DESCRIPTION
1	X	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

RELEASED
2010-09-16

SH 7/8/16 148825

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-15 MFG. APPR. <i>[Signature]</i> APPROVED <i>[Signature]</i> DE APPR. N/A DATE 10.04.28			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY		SCALE	NTS
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B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

B67-43001-83
D-PAD ASSEMBLY, SHORT

RELEASED
2010-09-16
MD

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 8.70 lbs
 - 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-15W AND B67-43001-83 TO B67-43001-73

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	B67-43001-15	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS
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